



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1121-W1
Job Sheet 192845



Part No: RBE1121-W1

Job Qty: 2 pcs

Part Name: Movable Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/19

Job Tracking No:

Due Date: 5/7/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE1121-W1 REV 1 IPP Rev. A 19.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	5/7/19		0.00	0.00	Purchasing - 1		MAY 09 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	5/7/19		0.00	0.00	Packaging 2 - 1 - B4B		MAY 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S179565



Part: RBE1121-W1

Job No: 192845

Serial No/Batch: S179565

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 05/09/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	5/7/19	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	MAY 09 2019 68
					QC 6 - 61	9-89
130 Small Fab - 2 - B4B	2 pcs	5/7/19	0.00 1.00		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	DAS
					Small Fab - 3 - B4B	71
					Small Fab - 4 - B4B	9-89
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	14-5-10
					Small Fab - 7 - B4B	
140 QC 5	2 pcs	5/7/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	MAY 10 2019 68
					QC 5 - 50	9-89
					QC 5 - 30	
					QC 5 - 40	
150 Packaging 3-1 - Stock - B4B	2 pcs	5/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21	DAG
				QC 21 - FG - 70	21 MAY 10 2019
				QC 21 - SA - 53	9-88

160 QC 21 - FG

2 pcs

5/7/19

0.00 0.00

QC 21 - FG - 21

DAG

QC 21 - FG - 70

21

MAY 10 2019

QC 21 - SA - 53

9-88

Part Op 100 - Purchasing - Issue PO to ARROW TECH MACHINE WORKS P/O: 043058 MANUFACTURE RBE1121-W1 AS
 Descriptions: PER DWG -Certificate of conformity is required

110 - Receive & Inspect for Damage & Mat'l Certs

120 - QC6- All purchased or subcontracted products

130 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBE1121-W1 3-Install placard using drive screws. .

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Releas

x2 Plus 02 APR 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE1121-W1P	Movable Beam	2 Ea (1 ea)	100-Purchasing	5179564
90081A074	0.125 X 0.500 #2 Drive Screw	8 Ea (4 ea)	130-Small Fab - 2 - B4B	5047591
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	130-Small Fab - 2 - B4B	5010767

61
1402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE1121-W1P	2	0	0
130-Small Fab - 2 - B4B	90081A074	8	139	0
	RB41011	2	365	0

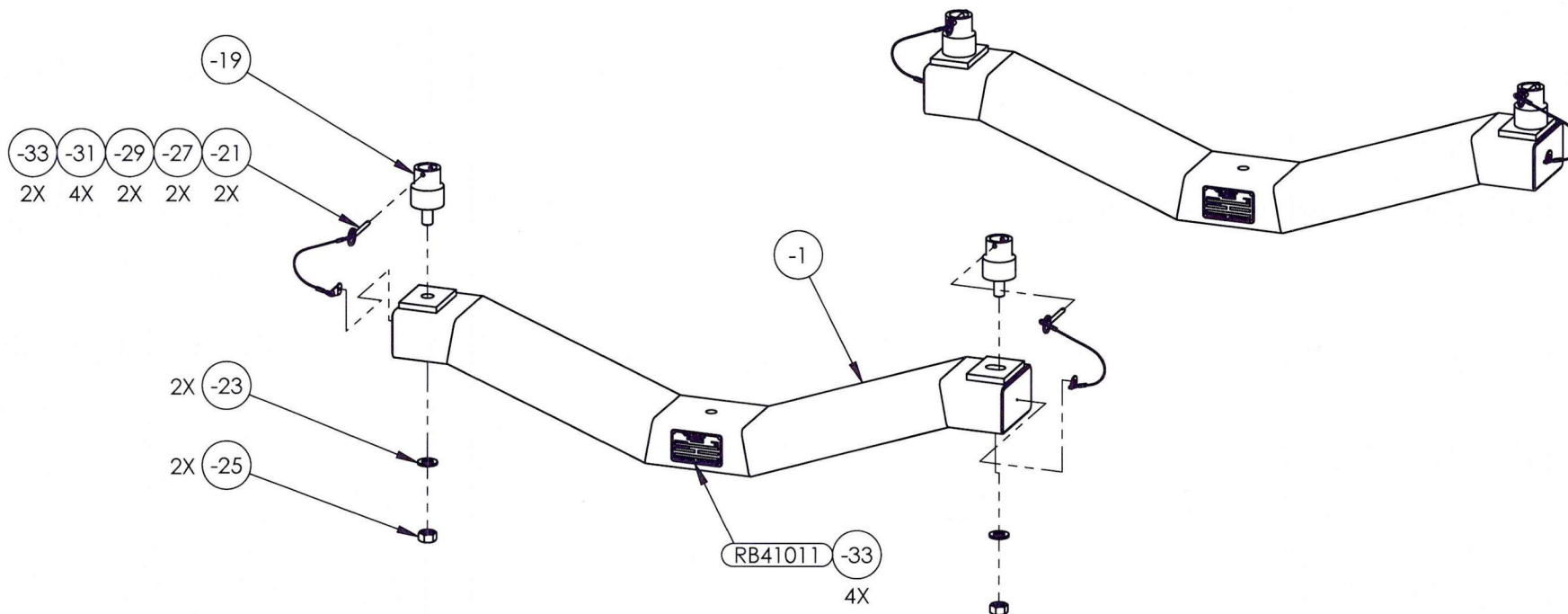
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/19/2016	DPD	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG
	X		-1	1	FRAME WELDMENT			2
	1		-3		MIDDLE TUBE	STEEL TUBE		3
	2		-5		END TUBE	STEEL TUBE		4
	2		-7		ANGLED TUBE	STEEL TUBE		5
	2		-9		END CAP	A36/1018/1020 HR		6
	1		-11		SOCKET	1018/1020 CR		7
	1		-13		THRU HOLE PLATE	A36/1018/1020 HR		8
	1		-15		SLOTTED PLATE	A36/1018/1020 HR		9
	1		-17		BALL	4140/4142		10
			-19	2	BUSHING	4140/4142		11
		B/O	-23	2	FLAT WASHER	STEEL	M16 (MCMASTER-CARR #91166A310)	1
		B/O	-31	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
		B/O	-33	6	#2 DRIVE SCREW	COATED STEEL	#2 X 1/8 (MCMASTER-CARR #90081A074)	1
		B/O	-25	2	HEX NUT	STEEL	M16 X 2 (MCMASTER-CARR #90591A220)	1
		B/O	-27	2	CABLE TAB	ALUMINUM	(CARR LANE #CL-129-TAB-A)	1
		B/O	-29	2	LANYARD	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	1
		B/O	-21	2	QUICK-RELEASE PIN	STEEL	M6 X 50mm USABLE (MCMASTER-CARR #95335A536)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1
	ASSY -1							

NOTE:
REF. EUROCOPTER T/N: 1121-W1.



MOVABLE BEAM

DWG NO.	RBE1121-W1
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RE	
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MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± .5°	
		.X ± .1 SURFACES = 125 ✓	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		EC145	
SCALE	1:10	DATE	7/20/2016
		SHEET 1 OF 11	



Quotation

PHGE Machine Works LLC dba
Arrow Tech Machine Works
29751 E. Enid Rd. Unit C
Eugene, Oregon 97402

Phone: (541) 780-6938
FAX: (458) 215-4938
Email: atechmachineworks@gmail.com

Date	Quote #
4/2/2019	256

Customer Details	Payment Terms	Sales Rep
DartAerospace	Withing 30 days due net	Gabriel Escobar
Contact		
Patrick Lussier		

Qty	Item	Description	Unit Price		Amount
1	RBE1121-W1 REV-1	MOVABLE BEAM	\$	3,094.00	\$ 3,094.00
2	"	"	\$	2,395.00	\$ 4,790.00

Thank You

Subtotal
Freight
Payment and Credit Applied
Total

4/1/2019

ORDER ACKNOWLEDGEMENT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CHELI54

Sold To: Helicopters Unlimited LLC

2740 Brierhaven Drive
La Crescenta, CA 91214
USA

Phone: 818-667-3492

Ship To: Western Helicopters Inc
10300 Airpark Way Hangar #3
PACOIMA, CA 91331
USA

ORDER

Order No : 14923

Date: 4/1/19

Ship-To Contact: Saro Garabetian

Email: heliunlimited@gmail.com

Cust PO No: N730TS-040119

FOB: Shipping Point

Ship Via: FedEx Express Saver (3 Day)

Freight Terms: PrePaid

Terms: Prepay

INCO Terms: Ex Works

Order Taker: Lacey Cantin

Order Taker Phone:

Order Taker Email: lcantin@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	5/6/19	5/6/19	RBE1121-W1	Movable Beam	1	pcs	\$6,166.00USD	pcs	\$6,166.00 USD
				5% Gold+ Discount			-5.00		\$-308.30
Sub Total									\$5,857.70 USD
Grand Total									\$5,857.70 USD

ORDER NOTES

TAX ID # 33-0692114
DO NOT INSURE
SHIP FEDEX EXPRESS ACCOUNT 226575936

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4/1/2019

ORDER ACKNOWLEDGEMENT

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

Latest Revision Provided Unless Otherwise Requested

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4/2/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043058



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: PO043058

PO Date: 4/2/19

Due Date: 5/7/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	192845	RBE1121-W1P			Movable Beam REV 1	Firmed	-	5/7/19	2 Ea	0 Ea	2 Ea	\$2,395.00/Ea	\$4,790.00

Grand Total: \$4,790.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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RECEIVED
4/2/19 AILB



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043058



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: PO043058

PO Date: 4/2/19

Due Date: 5/7/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	192845	RBE1121-W1P			Movable Beam REV 1	Firmed	-	5/7/19	2 Ea	0 Ea	2 Ea	\$2,395.00/Ea	\$4,790.00

Grand Total: \$4,790.00

Order Notes

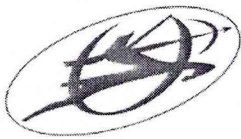
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
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A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 539

Date: 4/26/2019 ✓
PO Ref: 043058 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty ✓

2

Item

MOVABLE BEAM

Part No.

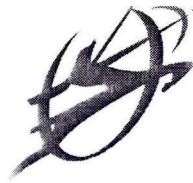
RBE1121-W1 ✓

Received by:

Packaged by: SM

Checked by: [Signature]

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 043058 ✓ Dated: 4/26/2019

Our Order / Job No: 043058-1AWT Order Qty: 2 ✓

Part Name: MOVEABLE BEAM

Part Number RBE1121-W1 ✓

Lot Size: N/A Ship Date: 4/26/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBE1121-W1 Rev: 1

Material Size and Type: -3, -5, -7/STEEL TUBE; -9, -11, -13, -15/1018; -17/4140; -19/4142Q&T

Material Specifications: 4140: ASTM A108; 1018: ASTM A29; STEEL TUBE:

Heat Treatment: (-19/RC 28-34)

Plating/Finish: POWDER COAT YELLOW: FED#13538; BLACK OXIDE: QMSI-6.2.2, B.O. REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/26/19

Signed: Herman M. Feld

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DAS
68
9-89